

**Work Order ID 64345**

Friday, December 03, 2010 3:11:52 PM



Page 1

Item ID: D4111-3

Accept



Setup Start



Revision ID:

Item Name: Sill Fitting

Stop



Start Date: 12/2/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/12/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
----------	--------------

D4111

B

100



Bandsaw

Jeaspa Bandsaw

0.00

12

110



HAAS 1

HAAS CNC vertical machine #1

0.00

12

Memo

MILL AS PER DWG AND FOLIO FA965

DWG REV: B

FOLIO REV: AA

2-DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4111-3 PAR #: Fault Category: Fracturing NCR: Yes No DQA: Date: 10/12/17  
 Resolution: SCVNP Disposition: SCVNP QA: N/C Closed: DD Date: 10/12/20

NCR: 64345		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/10/16	110	1 part scrap . prog not updated 1 part scrap pop out of the vice. RC program / COA.	DS1012	Scrap , destroy and replace Qty 1 Batch # 115355 * Program has been corrected	DSK 10/12/16	Y.A 10/12/17	DS1012	10/12/17

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

and 10/12/16

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

B. A 10/12/17

12

0

140



Packaging

Packaging

Identify as per dwg & Stock Location: 138

0.00

Memo

0.00

**Work Order ID 64345**

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Page 3

Item ID: D4111-3

Accept



Setup Start



Revision ID:

Item Name: Sill Fitting

Stop



Start Date: 12/2/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

10/12/2010  
U 10-12-17

Memo

0.00

**Picklist Print**

Page 1

Friday, December 03, 2010 3:11:58 PM

**Work Order ID:** 64345**Parent Item:** D4111-3**Parent Item Name:** Sill Fitting**Start Date:** 12/2/2010**Required Date:** 12/15/2010**Start Qty:** 12.00**Required Qty:** 12.00

**Comments:** IPP REV:A NEW ISSUE 10-09-24 JLM VERIFIED BY:DD  
10.12.03 as per dwg rev.B DD verf:EC IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000		Purchased		No		100	f	12.8290	0.21	2.652632			

303 BAR 1" X 1"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	11.6	
→ 115555	11.6	
MAT53	1.22896	
113719	1.22896	

2.653 *mf10h2610*

DART AEROSPACE LTD	Work Order:	64345
Description: SILL FITTING	Part Number:	D4111-3
Inspection Dwg:D4111 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

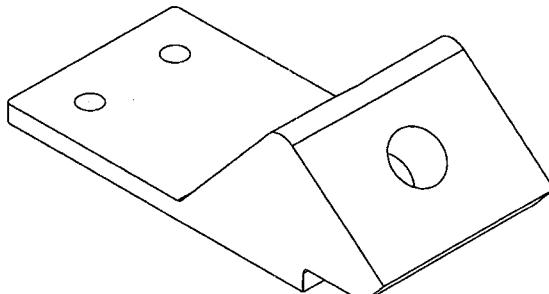
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.128	$\pm .005$	.128	—		burn	ML-7
.25	$\pm .030$	.242	—		"	"
.25	$\pm .030$	.252	—		"	"
.500	$\pm .010$	.499	—		"	"
1.00	$\pm .030$	.988	—		"	"
1.250	$\pm .010$	1.251	—		"	"
2.22	$\pm .030$	2.220	—		"	"
.50	$\pm .030$	.495	—		"	"
.313	$\pm .006$	.317	—		"	?
.640	$\pm .010$	.637	—		"	"
.100	$\pm .010$	.102	—		"	"
1.030	$\pm .030$	1.032	—		"	"
.894	$\pm .010$	.895	—		"	"
.300	$\pm .010$	.304	—		"	"
.86	$\pm .030$	.860	—		"	"
.74	$\pm .030$	.740	—		"	"
.18	$\pm .030$	.188	—		"	"
40°	$\pm 1/2^{\circ}$	40°	—		Comb-square	ML-CBB
.125	$\pm .010$	.123	—		Verin.	ML-7
.35	$\pm .030$	.342	—		"	"
1.75	$\pm .030$	1.758	—		"	"
.400	$\pm .010$	.400	—		"	"
.50	$\pm .030$	.495	—		"	?

Measured by:	amf	Audited by:	B.A	Prototype Approval:	N/A
Date:	10/12/16	Date:	10/12/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44345  
2/10-1

~~P1/10-AD-3~~

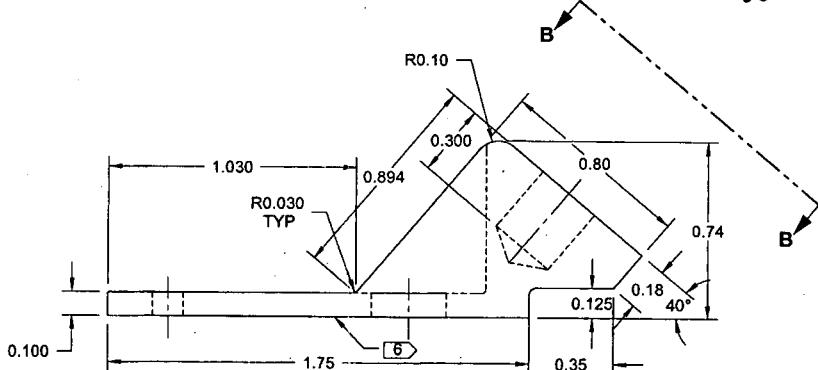
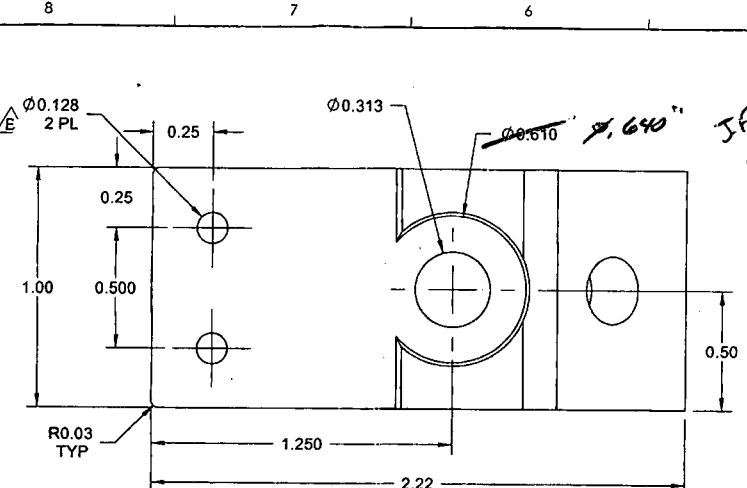


B

**D4111-3 SILL FITTING**

RELEASED 2010-11-30 BY SPK

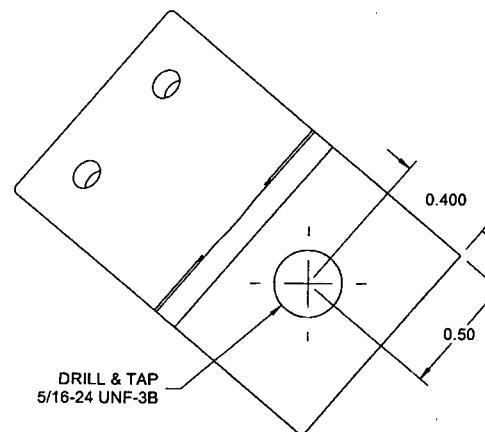
B	D4111-1 DELETED (REPLACED BY D4111-3 ON INSTL) D4111-3: Ø1.28 2 PL WAS 4 PL (DB-3) TO IMPROVE INSTL.			JPH	10.11.01
A	NEW ISSUE			JPH	10.07.20
REV.	DESCRIPTION			BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b>			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<i>[initials]</i>	DRAWING NO.	REV. E		
MFG. APPR.	<i>[initials]</i>	D4111	SHEET 1 OF		
APPROVED	<i>[initials]</i>	TITLE	SCALE		
DE APPR.	<i>[initials]</i>	SILL FITTING	NTS		
DATE	10.11.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>This document is private and confidential and supplied under the conditions that it is not to be used for any other purpose than the original purpose for which the person without written permission from Dart Aerospace Ltd.</small>			



D4111-3 SILL FITTING

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4111-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs



VIEW B-B

RELEASED  
2010-11-30  
*[Handwritten signature]*

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	
MFG. APPR.	<i>[Signature]</i>	D4111	REV. B
APPROVED	<i>[Signature]</i>	SHEET 2 OF 2	NTS
DE APPR.	<i>[Signature]</i>	TITLE	SCALE
DATE	10.11.01	SILL FITTING	NTS

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